

# ABS ER451H

## Injection Molding

### Description

Heat Resistance

### Application

Automotives Interior &amp; Exterior Housing (Garnish etc)

| Properties   | Test Condition | Test Method | Unit               | Typical Value |
|--|----------------|-------------|--------------------|---------------|
| <b>Physical</b>                                    |                |             |                    |               |
| Specific Gravity                                   |                | ASTM D792   | -                  | 1.05          |
| Molding Shrinkage (Flow), 3.2mm                    |                | ASTM D955   | %                  | 0.4~0.7       |
| Melt Flow Rate                                     | 220℃/10kg      | ASTM D1238  | g/10min            | 25            |
| <b>Mechanical</b>                                  |                |             |                    |               |
| Tensile Strength, 3.2mm                            |                | ASTM D638   |                    |               |
| @ Yield  | 50mm/min       |             | kg/cm <sup>2</sup> | 530           |
| Tensile Elongation, 3.2mm                          |                | ASTM D638   |                    |               |
| @ Yield  | 50mm/min       |             | %                  | >5            |
| @ Break  | 50mm/min       |             | %                  | 20            |
| Tensile Modulus, 3.2mm                             | 1mm/min        | ASTM D638   | kg/cm <sup>2</sup> | -             |
| Flexural Strength, 6.4mm                           | 15mm/min       | ASTM D790   | kg/cm <sup>2</sup> | 850           |
| Flexural Modulus, 6.4mm                            | 15mm/min       | ASTM D790   | kg/cm <sup>2</sup> | 27,000        |
| IZOD Impact Strength, 6.4mm<br>(Notched)           |                | ASTM D256   |                    |               |
|  | 23℃            |             | kg·cm/cm           | 15            |
|  | -30℃           |             | kg·cm/cm           | 8             |
| IZOD Impact Strength, 3.2mm<br>(Notched)           |                | ASTM D256   |                    |               |
|  | 23℃            |             | kg·cm/cm           | 27            |
|  | -30℃           |             | kg·cm/cm           | 12            |
| Rockwell Hardness                                  | R-Scale        | ASTM D785   | -                  | 110           |
| <b>Thermal</b>                                     |                |             |                    |               |
| Heat Deflection Temperature, 6.4mm<br>(Unannealed) |                | ASTM D648   |                    |               |
|  | 18.6kg         |             | ℃                  | 86            |
|  | 4.6kg          |             | ℃                  | 95            |
| Vicat Softening Temperature                        |                | ASTM D1525  |                    |               |
|  | 5kg, 50℃/h     |             | ℃                  | 93            |
| Flammability                                       |                | UL94        |                    | HB            |
| Relative Temperature Index                         |                | UL 746B     |                    |               |
| Electrical   |                |             | ℃                  |               |
| Mechanical with Impact                             |                |             | ℃                  |               |
| Mechanical without Impact                          |                |             | ℃                  |               |

Note) Typical values are only for material selection purpose, and variation within normal tolerances are for various colors.

Values given should not be interpreted as specification and not be used for part or tool design.

All properties, except melt flow rate are measured on injection molulded specimens and after 48 hours storage at 23℃, 50% relative humidity.

Dongguan Yi-Ming Plastic Chemical Co., Ltd.

如需要更多物性资料请查阅 [www.kedisujiao.com](http://www.kedisujiao.com)

备注：以上原料物性数据由厂家发布,我公司仅提供参考！数据如有变动，请联系原料生产厂家获知。我公司不承担任何法律责任！

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### Electrical

|  |            |           |        |   |
|--|------------|-----------|--------|---|
| Comparative Tracking Index(CTI)          | Solution A | IEC 60112 | Volts  | - |
| Surface Resistivity                      |            | IEC 60093 | Ohm    | - |
| Volume Resistivity                       | 23℃        | ASTM D257 | Ohm·m  | - |
| Arc Resistance                           | 23℃        | ASTM D495 | Ohm·cm | - |
| Dielectric Strength, 1mm                 | 23℃        | ASTM D149 | kV/mm  | - |
| Dielectric Constant (10 <sup>6</sup> Hz) | 23℃        | ASTM D150 | sec    | - |

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### Processing Guide (Injection Molding)

| Processing Parameters    |        | Unit               | Value     |
|--------------------------|--------|--------------------|-----------|
| Drying Temperature       |        | ℃                  | 80 ~ 90   |
| Drying Time              |        | hrs                | 3 ~ 4     |
| Minimum Moisture Content |        | %                  | 0.01      |
| Melt Temperature         |        | ℃                  | 210~230   |
| Cylinder Temperature     | Rear   | ℃                  | 180 ~ 200 |
|                          | Middle | ℃                  | 200 ~ 220 |
|                          | Front  | ℃                  | 220 ~ 230 |
| Nozzle Temperature       |        | ℃                  | 220 ~ 230 |
| Mold Temperature         |        | ℃                  | 40~60     |
| Back Pressure            |        | kg/cm <sup>2</sup> | 300~600   |
| Screw Speed              |        | rpm                | 50 ~ 100  |

Note) Back Pressure & Screw Speed are only mentioned as general guidelines.

These may not apply or need adjustment in specific situations such as low shot sizes, thin wall molding and gas-assist molding.

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